

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015559**Date Inspected:** 10-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao / Geng wei / Lv Liqian**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SMAW welding of weld joint 4G-240 located on PCMK SEG3005E for Segment 12AW the welder is identified as 067183. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2214-Tc-U4b-FCM-1.

Anchor sandwich plate welding is in progress for Lift 14, the plate is identified as X4743 and X4742.

OUTSIDE SHOP

11CW

SMAW welding of weld joint 4G-010 located on PCMK SEG069A for Segment 11CW the welder is identified as 066258. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G(4F)-Repair.

SMAW welding of weld joint 4G-020 located on PCMK OBW11E for Segment 11CW the welder is identified as 200113. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

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11DE

SMAW welding of weld joint 4G-037 located on PCMK OBE11E for Segment 11DE the welder is identified as 043661. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-Tc-U4b-FCM-1.

FCAW welding of weld joint 2F-003 located on PCMK SEG072G for Segment 11DE the welder is identified as 055664. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#16

SAW welding of weld joint 1G-004 located on PCMK BP3074-001or Segment 13AW the welder is identified as 045270. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

BAY#19

ZPMC personnel performing grinding on cope hole location where we found spatter, porosity, notch, sharp etches of segment SB52W,SB54W,SB56W,SB48W, SB48E.

End closure plate fit-up following Bike path BK004A-004 dimension and tack weld checked with ZPMC QC Mr. Xu tao appeared to comply with WPS.

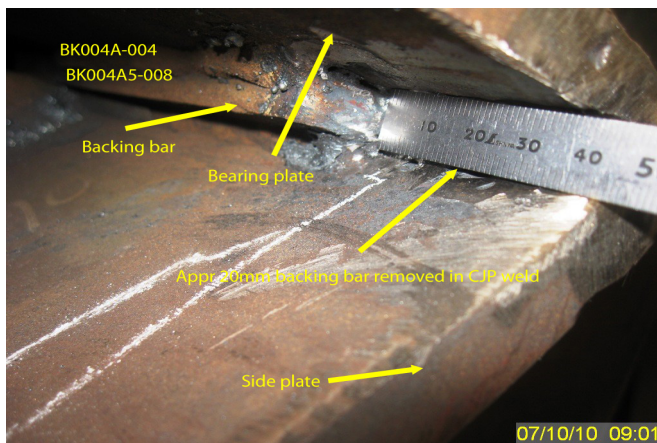
ZPMC personnel performing their grinding work for further Visual inspection of Bike path BK004A-010.

During fit-up of End closure plate with Bearing plate on BK004A-004, it is observed that ZPMC Personnel remove the backing bar 20mm on nearby CJP weld is identified as BK004A5-008. For more information please see the attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
